

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 73.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004617**Date Inspected:** 13-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** HoChang, Korea**Location:** Unyang, Korea

<b>CWI Name:</b>	N/A		
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** Pier E2 bearing and Shear key**Summary of Items Observed:**

The following report is based on METS observations at HoChang Machinery Industries. Current work: Casting, forging and machining.

On this date the Caltrans Quality Assurance (QA) inspector, Dong J. Shin arrived at Ho Chang Machinery Industries (HCMI) located at Unyang, Korea. The Purpose of this trip was to observe quality control during fabricate and process of following items.

**Forging**

1. Bearing Bottom Housing (B1-07/F07302-010): Completed normalizing and heat treating
2. Bearing Bottom Housing (B2-07/F07302-020): Completed normalizing and heat treating
3. Bearing Bottom Housing (B3-07/F07302-030): Completed normalizing and heat treating
4. Bearing Bottom Housing (B4-07/F07302-040): Completed normalizing and heat treating
5. Spherical Ring (S1-07/F07302-050): Move to HCMI for rough machining.
6. Spherical Ring (S2-07/F07302-060): Move to HCMI for rough machining.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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7. Spherical Ring (S3-07/F07302-070): Move to HCMI for rough machining.
8. Spherical Ring (S4-07/F07302-080): Move to HCMI for rough machining.
9. Solid Shaft (B1-02/F07302-090): Move to HCMI for rough machining.
10. Solid Shaft (B2-02/F07302-100): Move to HCMI for rough machining.
11. Solid Shaft (B3-02/F07302-110): Move to HCMI for rough machining.
12. Solid Shaft (B4-02/F07302-120): Move to HCMI for rough machining.

- F number is DooSan Production Number.
- B number is drawing Number .

### Casting

1. Bearing Top Housing(B1-06, C07039-010): Pattern making
2. Bearing Top Housing(B2-06, C07039-020)
3. Bearing Top Housing(B3-06, C07039-030)
4. Bearing Top Housing(B4-06, C07039-040)
5. Bearing Hold Down Assembly (B1-01-1, C07039-050)Pattern making
6. Bearing Hold Down Assembly (B1-01-2, C07039-060)Pattern making
7. Bearing Hold Down Assembly (B2-01-1, C07039-070)
8. Bearing Hold Down Assembly (B2-01-2, C07039-080)
9. Bearing Hold Down Assembly (B3-01-1, C07039-170)
10. Bearing Hold Down Assembly (B3-01-2, C07039-180)
11. Bearing Hold Down Assembly (B4-01-1, C07039-190)
12. Bearing Hold Down Assembly (B4-01-2, C07039-200)
13. Shear Key Stub(S1-01, C07039-090) : Pattern making

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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- 14. Shear Key Stub(S2-01, C07039-100) :
- 15. Shear Key Stub(S3-01, C07039-110) :
- 16. Shear Key Stub(S4-01, C07039-120) :
- 17. Shear key Housing(S1-03, C07039-130): pattern making
- 18. Shear key Housing(S1-03, C07039-130): pattern making
- 19. Shear key Housing(S1-03, C07039-130):
- 20. Shear key Housing(S1-03, C07039-130):

\* S and B number is drawing number.

\* C number is DSHI ID number

\* Blank is not started.

### Summary of Conversations:

Discuss with Mr. S H, Kwak regarding Fabrication procedure and NDT procedure comments.

Checked machining schedule of Spherical ring with Mr. SH Kwak.

Ask production schedule of casting.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jinesh K, Mehta (951) 840-0541, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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